

Date: Thursday, 3/8/2007 12:36:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR ARM
Job Number : 31100	
Estimate Number : 10335	
P.O. Number : N/A	Part Number : D2010104
This Issue : 3/8/2007 S.O. No. : N/A	Drawing Number : D2010 REV. C2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C2
Previous Run : 29772	Material : N/A
Written By : <u>JA</u>	Due Date : 3/30/2007 Qty: <u>11</u> Um: Each
Checked & Approved By : <u>JA 07.03.08</u>	
Comment : Est A 04.02.17 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 15.7500 f(s)  
 Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall  
 (M304TR0500W035) Batch No:

M103869x4mx

FF 07-03-15

14

M103453x4 / M102742x3

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC  
 Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
 Identify as D2010-104

FF 07-03-15

14

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
 2- Deburr

MF

07-05-03

(10)

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Plug

B 28655-

MF 07-05-03

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Install D2057 plug as per Dwg D2010

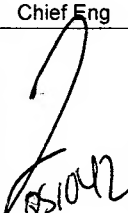
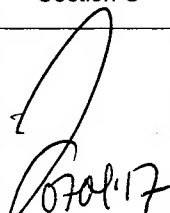

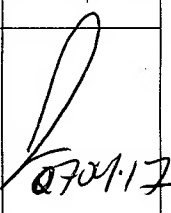
MF

07-05-07

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action . Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/17	1	3 piece were not good using material 1049 with 1035		Scrap & destroy	SB 07/04/17			

NOTE: Date & initial all entries

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Drawing Name: MIRROR ARM

Job Number: 31100

Part Number: D2010104

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/05/07

(11)

7.0

POWDER COATING

POWDER COATING



M102316



(11)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m.l

07/05/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/15

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/05/15

(11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/16

(11)

Job Completion



07-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

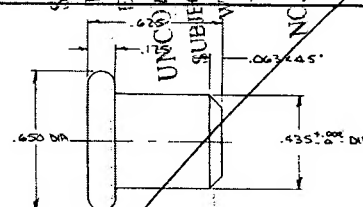
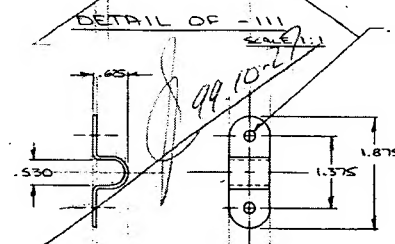
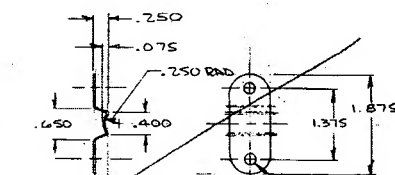
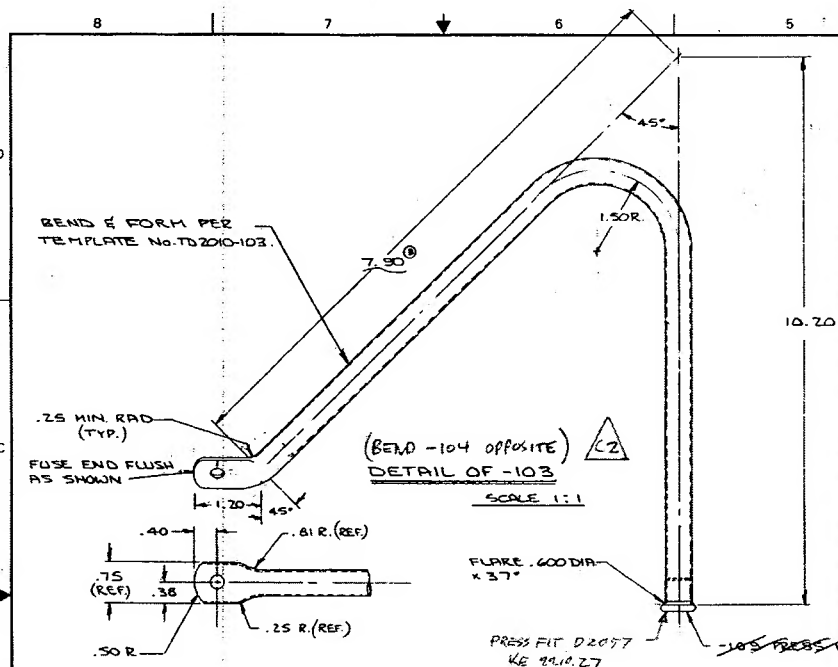
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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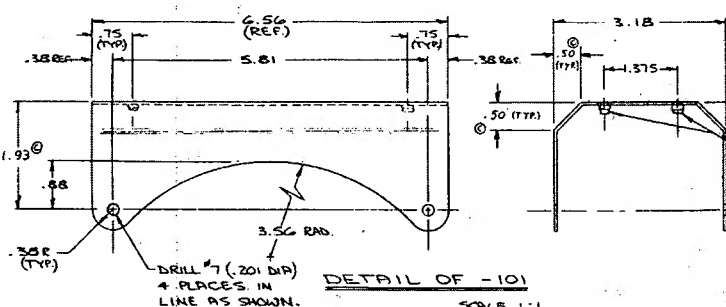


Superseded by D2057 rev B  
KE 24.12.19 ISRA1229

RELEASED  
64.02.03

# GENERAL NOTES:

1. BEND RADIUS FOR 2024-T3  
.063 THICK IS .188
2. PAINT -101 MATTE BLACK.
3. TYPE 304 STAINLESS STEEL MAY  
BE SUBSTITUTED WITH TYPES  
303 OR 316.
4. 2024-T3 MAY BE SUBSTITUTED  
WITH 2024-T3 CLAD (80-A-250/5).
- 103 FINISH: POWDER COAT BLACK SANDTEX  
(43.5.7) PER DART Q91 Q95 4.3  
INSTALL PER PEM INSTALLATION  
INSTRUCTIONS.



QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC. / VENDOR
4	FE-032-EF		FASTENER		PEW
	D 2010-113		CLAMP	.050 THICK	ALSI 304
	D 2010-111		SADDLE	.025 THICK	ALSI 304
1	D 2010-109		PLUG	.6061-T6 BAR	60-A-250/6
	D 2010-103		ARM	CREF TUBE 30 DIA x .050	ALSI 304
	D 2010-101		BRACKET	2024-T3 .063 THK	60-A-250/4

C2 04.12.24 02.05.25 01.01.26 01.01.27 01.01.28 01.01.29 01.01.30 01.01.31 01.01.32 01.01.33 01.01.34 01.01.35 01.01.36 01.01.37 01.01.38 01.01.39 01.01.40 01.01.41 01.01.42 01.01.43 01.01.44 01.01.45 01.01.46 01.01.47 01.01.48 01.01.49 01.01.50 01.01.51 01.01.52 01.01.53 01.01.54 01.01.55 01.01.56 01.01.57 01.01.58 01.01.59 01.01.60 01.01.61 01.01.62 01.01.63 01.01.64 01.01.65 01.01.66 01.01.67 01.01.68 01.01.69 01.01.70 01.01.71 01.01.72 01.01.73 01.01.74 01.01.75 01.01.76 01.01.77 01.01.78 01.01.79 01.01.80 01.01.81 01.01.82 01.01.83 01.01.84 01.01.85 01.01.86 01.01.87 01.01.88 01.01.89 01.01.90 01.01.91 01.01.92 01.01.93 01.01.94 01.01.95 01.01.96 01.01.97 01.01.98 01.01.99 01.02.00		REVISION DRAWN APPROVED DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED 1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISH SHALL BE 320 3. SURFACE FINISH SHALL BE 320 4. SURFACE FINISH SHALL BE 320 5. SURFACE FINISH SHALL BE 320 6. SURFACE FINISH SHALL BE 320 7. SURFACE FINISH SHALL BE 320 8. SURFACE FINISH SHALL BE 320 9. SURFACE FINISH SHALL BE 320 10. SURFACE FINISH SHALL BE 320 11. SURFACE FINISH SHALL BE 320 12. SURFACE FINISH SHALL BE 320 13. SURFACE FINISH SHALL BE 320 14. SURFACE FINISH SHALL BE 320 15. SURFACE FINISH SHALL BE 320 16. SURFACE FINISH SHALL BE 320 17. SURFACE FINISH SHALL BE 320 18. SURFACE FINISH SHALL BE 320 19. SURFACE FINISH SHALL BE 320 20. SURFACE FINISH SHALL BE 320 21. SURFACE FINISH SHALL BE 320 22. SURFACE FINISH SHALL BE 320 23. SURFACE FINISH SHALL BE 320 24. SURFACE FINISH SHALL BE 320 25. SURFACE FINISH SHALL BE 320 26. SURFACE FINISH SHALL BE 320 27. SURFACE FINISH SHALL BE 320 28. SURFACE FINISH SHALL BE 320 29. SURFACE FINISH SHALL BE 320 30. SURFACE FINISH SHALL BE 320 31. SURFACE FINISH SHALL BE 320 32. SURFACE FINISH SHALL BE 320 33. SURFACE FINISH SHALL BE 320 34. SURFACE FINISH SHALL BE 320 35. SURFACE FINISH SHALL BE 320 36. SURFACE FINISH SHALL BE 320 37. SURFACE FINISH SHALL BE 320 38. SURFACE FINISH SHALL BE 320 39. SURFACE FINISH SHALL BE 320 40. SURFACE FINISH SHALL BE 320 41. SURFACE FINISH SHALL BE 320 42. SURFACE FINISH SHALL BE 320 43. SURFACE FINISH SHALL BE 320 44. SURFACE FINISH SHALL BE 320 45. SURFACE FINISH SHALL BE 320 46. SURFACE FINISH SHALL BE 320 47. SURFACE FINISH SHALL BE 320 48. SURFACE FINISH SHALL BE 320 49. SURFACE FINISH SHALL BE 320 50. SURFACE FINISH SHALL BE 320 51. SURFACE FINISH SHALL BE 320 52. SURFACE FINISH SHALL BE 320 53. SURFACE FINISH SHALL BE 320 54. SURFACE FINISH SHALL BE 320 55. SURFACE FINISH SHALL BE 320 56. SURFACE FINISH SHALL BE 320 57. SURFACE FINISH SHALL BE 320 58. SURFACE FINISH SHALL BE 320 59. SURFACE FINISH SHALL BE 320 60. SURFACE FINISH SHALL BE 320 61. SURFACE FINISH SHALL BE 320 62. SURFACE FINISH SHALL BE 320 63. SURFACE FINISH SHALL BE 320 64. SURFACE FINISH SHALL BE 320 65. SURFACE FINISH SHALL BE 320 66. SURFACE FINISH SHALL BE 320 67. SURFACE FINISH SHALL BE 320 68. SURFACE FINISH SHALL BE 320 69. SURFACE FINISH SHALL BE 320 70. SURFACE FINISH SHALL BE 320 71. SURFACE FINISH SHALL BE 320 72. SURFACE FINISH SHALL BE 320 73. SURFACE FINISH SHALL BE 320 74. SURFACE FINISH SHALL BE 320 75. SURFACE FINISH SHALL BE 320 76. SURFACE FINISH SHALL BE 320 77. SURFACE FINISH SHALL BE 320 78. SURFACE FINISH SHALL BE 320 79. SURFACE FINISH SHALL BE 320 80. SURFACE FINISH SHALL BE 320 81. SURFACE FINISH SHALL BE 320 82. SURFACE FINISH SHALL BE 320 83. SURFACE FINISH SHALL BE 320 84. SURFACE FINISH SHALL BE 320 85. SURFACE FINISH SHALL BE 320 86. SURFACE FINISH SHALL BE 320 87. SURFACE FINISH SHALL BE 320 88. SURFACE FINISH SHALL BE 320 89. SURFACE FINISH SHALL BE 320 90. SURFACE FINISH SHALL BE 320 91. SURFACE FINISH SHALL BE 320 92. SURFACE FINISH SHALL BE 320 93. SURFACE FINISH SHALL BE 320 94. SURFACE FINISH SHALL BE 320 95. SURFACE FINISH SHALL BE 320 96. SURFACE FINISH SHALL BE 320 97. SURFACE FINISH SHALL BE 320 98. SURFACE FINISH SHALL BE 320 99. SURFACE FINISH SHALL BE 320 100. SURFACE FINISH SHALL BE 320		REPORT ALL DISCREPANCIES - DO NOT SCALE	
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**DART** DART AERO ACCESSORIES LTD  
VANCOUVER CANADA

MIRROR BRACKET DETAILS  
D2010

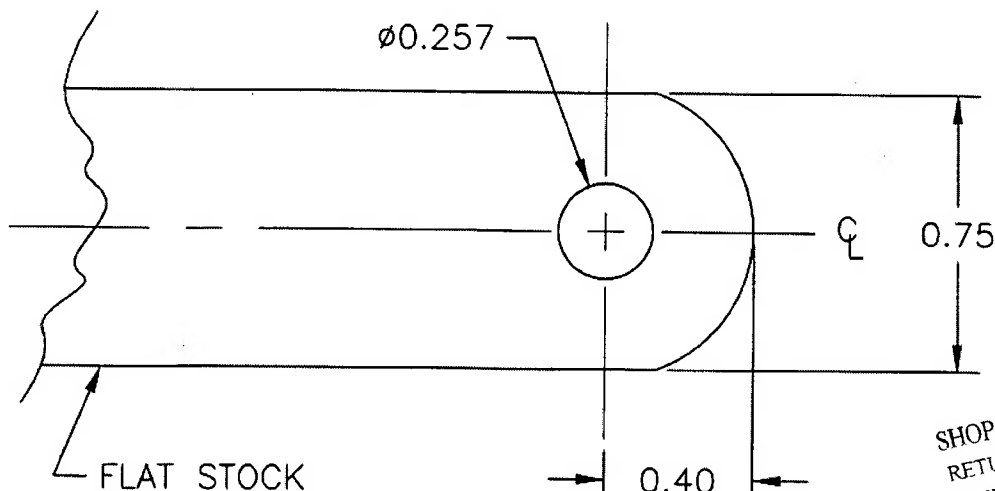
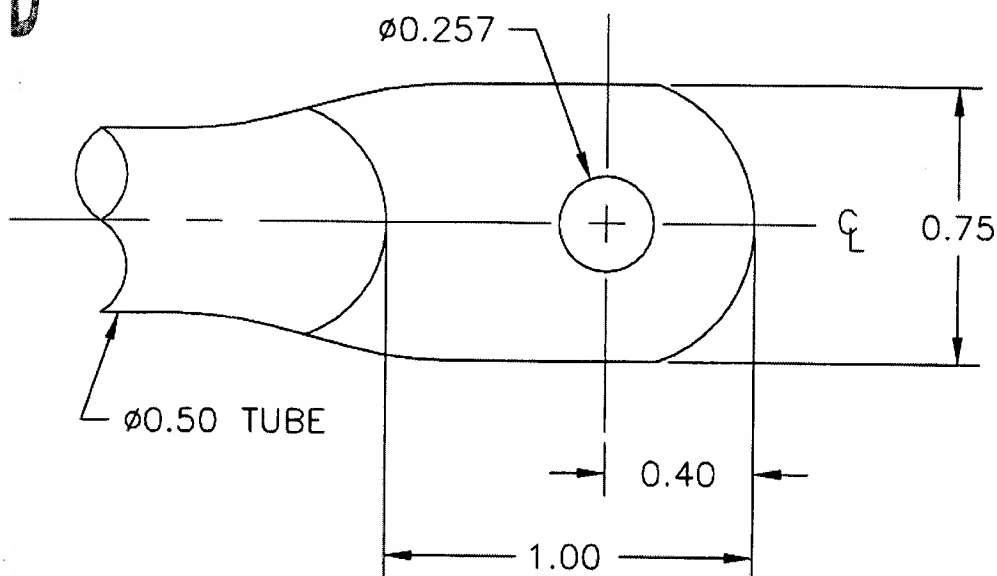
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>my</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL SCALE 2:1	
A	97.11.24	NEW ISSUE	
A1	<del>FCP</del> 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

**RELEASED**  
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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